

FORM PTO-1390 (REV 10-97)		U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE		ATTORNEY'S DOCKET NUMBER 01099/TL	
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371				U.S. APPLICATION NO. (If known, see 37 CFR 1.5) 09/807106	
INTERNATIONAL APPLICATION NO. PCT/AT99/00240		INTERNATIONAL FILING DATE 5 October 1999		PRIORITY DATE CLAIMED 9 October 1998	
TITLE OF INVENTION METHOD AND PLANT FOR CONTINUOUSLY PRODUCING CONSTRUCTION ELEMENTS					
APPLICANT(S) FOR DO/EO/US Klaus RITTER; Gerhard RITTER (Deceased); Gerhard SCHMIDT					

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

- ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
- ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
- ☒ This express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).
- ☒ A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.
- ☒ A copy of the International Application as filed (35 U.S.C. 371(c)(2))
 - ☐ is transmitted herewith (required only if not transmitted by the International Bureau).
 - ☒ has been transmitted by the International Bureau.
 - ☐ is not required, as the application was filed in the United States Receiving Office (RO/US).
- ☒ A translation of the International Application into English (35 U.S.C. 371(c)(2)).
- ☐ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))
 - ☐ are transmitted herewith (required only if not transmitted by the International Bureau).
 - ☐ have been transmitted by the International Bureau.
 - ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - ☐ have not been made and will not be made.
- ☐ A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
- ☐ An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).
- ☐ A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)).

Items 11. to 16. below concern document(s) or information included:

- ☒ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
- ☐ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
- ☒ A FIRST preliminary amendment.
☐ A SECOND or SUBSEQUENT preliminary amendment.
- ☐ A substitute specification.
- ☐ A change of power of attorney and/or address letter.
- ☒ Other items or information:
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Yolanda Usher
Yolanda Usher



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PCT

Attorney Docket No. 01099/TL

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**IN THE UNITED STATES PATENT
AND TRADEMARK OFFICE**

Applicant(s): Klaus RITTER et al.

Serial No. : 09/807,106

Filed : April 9, 2001

For : METHOD AND PLANT FOR
CONTINUOUSLY PRODUCING
CONSTRUCTION

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Yolanda Usher
Yolanda Usher

SUPPLEMENTAL PRELIMINARY AMENDMENT

Asst. Commissioner for Patents
Washington, D.C. 20231

S I R :

This is supplemental to the Preliminary Amendment filed concurrently with the filing of the above-captioned application.

IN THE CLAIMS:

Please amend claims 14 and 15 as follows (see changes shown in the attachment hereto):

14. (Twice amended) Apparatus according to claim 8, characterised in that the cutting device (7) is arranged in front of the conveying device (18) for the insulating body (K) and in that in the region between the feeder (12) for the insulating panels (I1', I2') and the conveying device (18) for the insulating body (K) are provided support elements (47) movable into the path of advance of the web of insulating material (B).

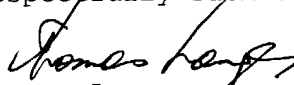
15. (Twice amended) Apparatus according to claim 8, characterized in that a transporter (29, 29') is provided for taking wire mesh mats (M, M') already cut to length from at least one stack of mats (28, 28'), and an insertion device (31, 31') is provided for insertion of the wire mesh mats (M, M') in a shaping device (32, 32'), and a drivable advance roller

(33, 33') is provided for insertion of the straightened wire mesh mats (M, M') in the production line (Z-Z), wherein the advance roller (33, 33') is coupled to the conveying device (12) for the web of insulating material (B) and insulating body (K), the conveying devices (27, 27') for the wire mesh mats (M, M'), the conveying devices (37, 37') for the mesh body (H) and, if occasion arises, to the advance roller (21, 21') for a wire mesh web (G, G').

R E M A R K S

This is a Supplemental Preliminary Amendment to correct typographical errors made in claims 14 and 15. In particular, in claim 14, the phrase "and in that in the region between the feeder (12) for the insulating panels (I1, I2') and the conveying device (18) for the insulating body (K)" which was inadvertently omitted from the claim is now being inserted. In claim 15, the word "derivable" has been replaced with the original word "drivable".

Respectfully submitted,


Thomas Langer
(Reg. No. 27,264)

Frishauf, Holtz, Goodman, Langer & Chick, P.C.
767 Third Avenue - 25th Floor
New York, New York 10017-2032
Tel. No. (212) 319-4900
Facsimile No. (212) 319-5101
TL:yu

COPY OF AMENDED CLAIMS SHOWING CHANGES MADE TO CLAIMS

USSN 09/807,106

14. (Twice amended) Apparatus according to claim 8, characterised in that the cutting device (7) is arranged in front of the conveying device (18) for the insulating body (K) and in that in the region between the feeder (12) for the insulating panels (I1', I2') and the conveying device (18) for the insulating body (K) are provided support elements (47) movable into the path of advance of the web of insulating material (B).

15. (Twice amended) Apparatus according to claim 8, characterized in that a transporter (29, 29') is provided for taking wire mesh mats (M, M') already cut to length from at least one stack of mats (28, 28'), and an insertion device (31, 31') is provided for insertion of the wire mesh mats (M, M') in a shaping device (32, 32'), and a ^{drivable}~~derivable~~ advance roller (33, 33') is provided for insertion of the straightened wire mesh mats (M, M') in the production line (Z-Z), wherein the advance roller (33, 33') is coupled to the conveying device (12) for the web of insulating material (B) and insulating body (K), the conveying devices (27, 27') for the wire mesh mats (M, M'), the conveying devices (37, 37') for the mesh body (H) and, if occasion arises, to the advance roller (21, 21') for a wire mesh web (G, G').

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JC02 Rec'd PCT/PTO 09 APR 2001

Attorney Docket No. 01099/TL

**IN THE UNITED STATES PATENT
AND TRADEMARK OFFICE**

Applicant(s): Klaus RITTER et al.

Serial No. : Not Yet Assigned (U.S. Natl.
Phase of PCT/AT99/00240
Filed 5 October 1999)

Filed : Concomitantly herewith

For : METHOD AND PLANT FOR
CONTINUOUSLY PRODUCING
CONSTRUCTION

PRELIMINARY AMENDMENT

Asst. Commissioner for Patents
Washington, D.C. 20231

S I R :

Please amend the above-identified application as follows:

IN THE TITLE

Please insert the following title (as shown in the attachment
hereto):

--METHOD AND PLANT FOR CONTINUOUSLY PRODUCING CONSTRUCTION--.

IN THE SPECIFICATION

Before line 1, insert the following as the first paragraph of the
specification (as shown in the attachment hereto):

--This application is a U.S. National Phase Application under 35
USC 371 of International Application PCT/AT99/00240 (not published in
English) filed 5 October 1999.--

IN THE CLAIMS:

Please amend claims 3, 5, 6-8 and 11-15 as follows (see changes
shown in the attachment hereto):

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D.C. 20231

Yolanda Usher
Yolanda Usher

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and the necessary petition for extension of
time is not filed concurrently herewith,
please consider this as a Petition for the
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authorization to charge the extension fee, or
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this Paper, to Account
No. 06-1378.

3. (Amended) Method according to claim 1, characterised in that, to produce the endless, coherent web of insulating material (B), the insulating panels (I1, I1') are joined together with their faces (N, F) in form-locking and force-locking relationship by
5 clamping.

5. (Amended) Method according to claim 3, characterised in that the faces (N, F) are provided with an adhesive.

6. (Amended) Method according to claim 1, characterised in that insulating panels (I2, I2') with plane faces (E) are used and, to produce the endless, coherent web of insulating material (B), an adhesive is applied to at least one face (E) of adjacent insulating
5 panels (I2, I2') or the face is provided with a self-adhesive film.

7. (Amended) Method according to claim 1, characterized in that insulating panels (I2, I2') with plane faces (E) are used and, to produce the endless, coherent web of insulating material (B), the face (E) of one insulating panel (I2') and the end face of the
5 web of insulating material (B) are heated together and joined by welding.

8. (Amended) Apparatus for carrying out the method according to claim 1, with two storage magazines for wire mesh webs, with straightening and cutting devices for each wire mesh web, with a
10 feeder for insulating panels, with at least one assembly of link wire storage reels together with associated link wire feeders and cutting devices, with link wire welding devices, with link wire trimming devices, and with several conveying devices coupled

together for the insulating body, for the wire mesh webs or for
15 wire mesh mats for the mesh body and for the structural member,
characterized in that an advance mechanism (16) for the
displacement of insulating panels (I1, I1'; I2, I2') relative to a
web of insulating material (B) for the purpose of forming a form-
locking and force-locking joint between the insulating panels (I1,
20 I1'; I2, I2') and the web of insulating material (B), and a cutting
device (7) displaceable parallel to the production line (Z-Z) for
cutting an insulating body (K) off the web of insulating material
(B), are provided.

11. (Amended) Apparatus according to claim 8, characterised
in that, to produce the web of insulating material (B), there is
provided a heating plate (45) with which the face (E) of one
insulating panel (I2') and the end face of the web of insulating
5 material (B) can be heated together.

12. (Amended) Apparatus according to claim 8, characterized
in that, to produce the web of insulating material (B), there is
provided at least one adhesive device (49) which is movable in
horizontal and vertical directions and with which at least one face
5 (E) of adjacent insulating panels (I2') can be provided with an
adhesive coat.

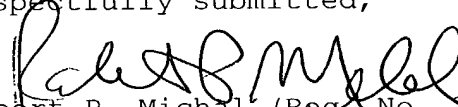
13. (Amended) Apparatus according to claim 8, characterized
in that the cutting device (7) is arranged behind the trimming
devices (6, 6') in the direction of production.

14. (Amended) Apparatus according to claim 8, characterised
in that the cutting device (7) is arranged in front of the

conveying device (18) for the insulating body (K) are provided
support elements (47) movable into the path of advance of the web
5 of insulating material (B).

15. (Amended) Apparatus according to claim 8, characterized
in that a transporter (29, 29') is provided for taking wire mesh
mats (M, M') already cut to length from at least one stack of mats
(28, 28'), and an insertion device (31, 31') is provided for
5 insertion of the wire mesh mats (M, M') in a shaping device (32,
32'), and a derivable advance roller (33, 33') is provided for
insertion of the straightened wire mesh mats (M, M') in the
production line (Z-Z), wherein the advance roller (33, 33') is
coupled to the conveying device (12) for the web of insulating
10 material (B) and insulating body (K), the conveying devices (27,
27') for the wire mesh mats (M, M'), the conveying devices (37,
37') for the mesh body (H) and, if occasion arises, to the advance
roller (21, 21') for a wire mesh web (G, G').

Respectfully submitted,



Robert P. Michal (Reg. No. 35,614)
For Thomas Langer (Reg. No. 27,264)

Frishauf, Holtz, Goodman, Langer & Chick, P.C.
767 Third Avenue - 25th Floor
New York, New York 10017-2032
Tel. No. (212) 319-4900
Facsimile No. (212) 319-5101
RPM:TL:yu

COPY OF AMENDED CLAIMS SHOWING CHANGES MADE TO CLAIMS
(U.S. Natl. Phase Appln. of
PCT/AT99/00240)

3. (Amended) Method according to claim 1 [either of
claims 1 or 2], characterised in that, to produce the endless,
coherent web of insulating material (B), the insulating panels
(I1, I1') are joined together with their faces (N, F) in form-
5 locking and force-locking relationship by clamping.

5. (Amended) Method according to claim 3 [either of
claims 3 or 4], characterised in that the faces (N, F) are
provided with an adhesive.

6. (Amended) Method according to claim 1 [either of
claims 1 or 2], characterised in that insulating panels (I2, I2')
with plane faces (E) are used and, to produce the endless,
coherent web of insulating material (B), an adhesive is applied
5 to at least one face (E) of adjacent insulating panels (I2, I2')
or the face is provided with a self-adhesive film.

7. (Amended) Method according to claim 1 [either of
claims 1 or 2], characterized in that insulating panels (I2, I2')
with plane faces (E) are used and, to produce the endless,
coherent web of insulating material (B), the face (E) of one
5 insulating panel (I2') and the end face of the web of insulating
material (B) are heated together and joined by welding.

8. (Amended) Apparatus for carrying out the method according to claim 1 [any of claims 1 to 7], with two storage magazines for wire mesh webs, with straightening and cutting devices for each wire mesh web, with a feeder for insulating panels, with at least one assembly of link wire storage reels together with associated link wire feeders and cutting devices, with link wire welding devices, with link wire trimming devices, and with several conveying devices coupled together for the insulating body, for the wire mesh webs or for wire mesh mats for the mesh body and for the structural member, characterized in that an advance mechanism (16) for the displacement of insulating panels (I1, I1'; I2, I2') relative to a web of insulating material (B) for the purpose of forming a form-locking and force-locking joint between the insulating panels (I1, I1'; I2, I2') and the web of insulating material (B), and a cutting device (7) displaceable parallel to the production line (Z-Z) for cutting an insulating body (K) off the web of insulating material (B), are provided.

11. (Amended) Apparatus according to claim 8 [any of claims 8 to 10], characterised in that, to produce the web of insulating material (B), there is provided a heating plate (45) with which the face (E) of one insulating panel (I2') and the end face of the web of insulating material (B) can be heated together.

12. (Amended) Apparatus according to claim 8 [any of
claims 8 to 10], characterized in that, to produce the web of
insulating material (B), there is provided at least one adhesive
10 device (49) which is movable in horizontal and vertical
directions and with which at least one face (E) of adjacent
insulating panels (I2') can be provided with an adhesive coat.

13. (Amended) Apparatus according to claim 8 [any of
claims 8 to 12], characterized in that the cutting device (7) is
arranged behind the trimming devices (6, 6') in the direction of
production.

14. (Amended) Apparatus according to claim 8 [any of
claims 8 to 12], characterised in that the cutting device (7) is
arranged in front of the conveying device (18) for the insulating
body (K) are provided support elements (47) movable into the path
5 of advance of the web of insulating material (B).

15. (Amended) Apparatus according to claim 8 [any of
claims 8 to 14], characterized in that a transporter (29, 29') is
provided for taking wire mesh mats (M, M') already cut to length
from at least one stack of mats (28, 28'), and an insertion
5 device (31, 31') is provided for insertion of the wire mesh mats
(M, M') in a shaping device (32, 32'), and a derivable advance
roller (33, 33') is provided for insertion of the straightened

wire mesh mats (M, M') in the production line (Z-Z), wherein the advance roller (33, 33') is coupled to the conveying device (12)
10 for the web of insulating material (B) and insulating body (K), the conveying devices (27, 27') for the wire mesh mats (M, M'), the conveying devices (37, 37') for the mesh body (H) and, if occasion arises, to the advance roller (21, 21') for a wire mesh web (G, G').

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09/807106

JC02 Rec'd PCT/PTO 09 APR 2001

The invention concerns a method and an apparatus for the continuous manufacture of structural members consisting of two parallel, flat wire mesh mats comprising longitudinal and transverse wires intersecting with each other and welded together at the points of intersection, straight link wires which keep the wire mesh mats a predetermined distance apart, and an insulating body arranged between the wire mesh mats and penetrated by the link wires.

From WO 96/03234 is known an apparatus comprising two storage magazines for wire mesh webs or wire mesh mats, straightening and cutting devices for each wire mesh web, a feeder for insulating panels, at least one assembly of link wire storage reels together with associated link wire feeders and cutting devices, link wire welding devices, link wire trimming devices, and several conveying elements coupled together for the wire mesh webs or wire mesh mats, for the insulating body and for the structural member.

In this known apparatus, two straightened wire mesh webs each taken off a storage reel are divided up into wire mesh mats of the desired length and the wire mesh mats produced in this way are brought into a parallel position with a distance between them corresponding to the desired thickness of the structural member to be manufactured. There is also provision for the feeding of wire mesh mats already cut to length. Into the gap between the wire mesh mats and with a selectable distance from the wire mesh mats is introduced an insulating body which is either separated from a web of insulating material or supplied as a single panel. The two wire mesh mats are fed together with the insulating body to the link wire feeders and cutting devices in which first several wires are simultaneously taken off storage reels in vertical rows one above the other, straightened and divided up into link wires of the required length, and then the link wires are pushed from the side through the holes in the two wire mesh mats and the insulating body, wherein each link wire with its ends comes to lie close to a wire of the wire mesh mats. The

Detailed changes to specification
U.S. Natl. Phase of PCT/AT99/00240

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--METHOD AND PLANT FOR CONTINUOUSLY PRODUCING CONSTRUCTION--

--This application is a U.S. National Phase Application under 35 USC 371 of International Application PCT/AT99/00240 (not published in English) filed 5 October 1999.--

The invention concerns a method and an apparatus for the continuous manufacture of structural members consisting of two parallel, flat wire mesh mats comprising longitudinal and transverse wires intersecting with each other and welded together at the points of intersection, straight link wires which keep the wire mesh mats a predetermined distance apart, and an insulating body arranged between the wire mesh mats and penetrated by the link wires.

From WO 96/03234 is known an apparatus comprising two storage magazines for wire mesh webs or wire mesh mats, straightening and cutting devices for each wire mesh web, a feeder for insulating panels, at least one assembly of link wire storage reels together with associated link wire feeders and cutting devices, link wire welding devices, link wire trimming devices, and several conveying elements coupled together for the wire mesh webs or wire mesh mats, for the insulating body and for the structural member.

In this known apparatus, two straightened wire mesh webs each taken off a storage reel are divided up into wire mesh mats of the desired length and the wire mesh mats produced in this way are brought into a parallel position with a distance between them corresponding to the desired thickness of the structural member to be manufactured. There is also provision for the feeding of wire mesh mats already cut to length. Into the gap between the wire mesh mats and with a selectable distance from the wire mesh mats is introduced an insulating body which is either separated from a web of insulating material or supplied as a single panel. The two wire mesh mats are fed together with the insulating body to the link wire feeders and cutting devices in which first several wires are simultaneously taken off storage reels in vertical rows one above the other, straightened and divided up into link wires of the required length, and then the link wires are pushed from the side through the holes in the two wire mesh mats and the insulating body, wherein each link wire with its ends comes to lie close to a wire of the wire mesh mats. The

Preferably the insulating panels are conveyed singly

and successively onto the production line and displaced relative to each other in their longitudinal direction to produce the web of insulating material, with the result that the faces of the adjacent insulating panels are joined together in form-locking and force-locking relationship to form the web of insulating material.

Alternatively it is provided that insulating panels with plane faces are used and, to produce the endless, coherent web of insulating material, an adhesive is applied to at least one face of adjacent insulating panels or the face is provided with a self-adhesive film.

The subject of the invention is further an apparatus for carrying out the method, with two storage magazines for wire mesh webs, with straightening and cutting devices for each wire mesh web, with a feeder for insulating panels, with at least one assembly of link wire storage reels together with associated link wire feeders and cutting devices, with link wire welding devices, with link wire trimming devices, and with several conveying devices coupled together for the insulating body, for the wire mesh webs or for wire mesh mats, for the mesh body and for the structural member, characterised in that an advance mechanism for the displacement of insulating panels relative to a web of insulating material for the purpose of forming a form-locking and force-locking joint between the insulating panels and the web of insulating material, and a cutting device displaceable parallel to the production line for cutting an insulating body off the web of insulating material, are provided. Alternatively the cutting device comprises a cutting wire which is displaceable transversely to the web of insulating material and heatable by means of a heating transformer.

Further characteristics and advantages of the invention are described in more detail below from practical examples with reference to the drawings. These show:

Fig. 1 a schematic top view of an apparatus according to the invention;

Fig. 2 a further practical example of feeding the

Fig. 3 a further practical example of feeding the material to the apparatus according to the invention.

The apparatus consists, seen in the direction of production P1, of an insulating material feeder 1, a wire mesh web feeder 2, a wire mesh mat feeder 3', two link wire feeders 4, 4', two link wire welding devices 5, 5', two trimming devices 6, 6', a cutting device 7 for cutting through the web of insulating material B and a structural member conveying device 8.

The insulating material feeder 1 comprises an insertion device 9 which supplies the apparatus with the insulating panels I1 designed to form the insulating body K of the structural member P, in the arrow direction P2 of the production line Z-Z. The insulating panels I1 are provided with a groove N on one face and with a tongue F on the other, opposite face, groove and tongue being designed in such a way that the tongue of one insulating panel I1 fits in form-locking and force-locking relationship in the groove of another insulating panel. The insertion device 9 consists of two work cylinders whose piston rods are moved according to the double arrow P3 and are provided with a

pressure plate 11 at their end. On the production line Z-Z is arranged a conveyor belt 12 which is drivable in the direction of production P1 with the aid of a conveying drive 13 and advances the insulating panel I1 in this direction along the production line Z-Z. Fixed to a frame 14 is a transversely slidable stop frame 15 which limits the feed movement P2 of the insulating panels I1 and precisely fixes the position of the insulating panels I1 on the production line Z-Z. On the input side of the conveyor belt 12 is arranged an advance mechanism 16, for example a work cylinder. The piston rod of the work cylinder 16 is movable according to the double arrow P4 and provided with a contact pressure plate 17 adapted to the grooved face of the insulating panel I1. By means of the advance mechanism 16 the insulating panel I1' which is located on the conveyor belt 12 is additionally advanced according to the arrow P1 in order to move the insulating panel I1' relative to the web of insulating material B already formed and so join the insulating panel I1' in form-locking and force-locking relationship to the end of the web of insulating material B and produce an endless, coherent web of insulating material B. In the process the tongue of the insulating panel I1' engages in the groove of the end element of the web of insulating material B. The grooves and tongues are coordinated with each other in their design in such a way that a form-locking and force-locking joint is formed, which ensures both alignment of the insulating panels I1, I1' to be joined and rigid joining thereof.

The conveyor belt 12 is followed by a transport chain 18 which extends over the whole production line Z-Z and which is drivable in the direction of production P1 and moves the web of insulating material B on the production line Z-Z cyclically in the direction of production P1. The junction between the conveyor belt 12 and the beginning of the transport chain 18 is bounded laterally by side plates 19, 19' in order to avoid lateral yielding of the insulating panels I1' when joining adjacent insulating panels I1' to form the web of insulating material B. The

From a storage reel 20 a wire mesh web G standing edgewise is taken off in the arrow direction P5 by means of an advance roller 21 drivable according to the double arrow P6, and fed to a straightening device 22. The straightening device 22 consists of two rows of straightening rollers 23 and adjustable eccentric rollers 24 offset from each other. By means of the advance rollers 21 the wire mesh web G is fed stepwise to a cutting device 25 which essentially comprises a cooperating pair of cutter bars 26 and cuts wire mesh mats M of predetermined length off an endless wire mesh web G. The cutting device 25 in the embodiment shown works so as to cut a selectable piece out of the wire mesh web G in a so-called Gassel cut, so that the wire mesh mats M fed to the production line Z-Z succeed each other at a distance. Within the scope of the invention, however, it is also possible to design and control the cutting device 25 in such a way that a separating cut or trimming cut is performed.

From a stack 28' of mats, wire mesh mats M' are taken successively by means of a transporter 29' which is pivotable according to the double arrow P8', and deposited in a receiving rail 30. By means of an insertion device 31'

devices 6, 6' in which the link wire ends projecting beyond the wires L or Q of the wire mesh mats M, M' are cut off level.

By means of the pairs of conveying elements 37, 37' the mesh body H together with the web of insulating material B is fed to the cutting device 7. The cutting device 7 cuts off the insulating body K in a selectable length from the web of insulating material B and comprises at least one separating disc 39 drivable with a cutting drive 38. To increase the cutting output a further separating disc 39' together with drive 37' may be used. The cutting device 7 is moved during cutting synchronously with the advance movements of the pairs of conveying elements 27, 27' and 37, 37' in the direction of production P1 and, after cutting is done, returned to the starting position, these movements being effected according to the double arrow P14. The movement into the cutting position and the corresponding return from the cutting position are effected according to the double arrow P15. The length of the insulating body K can within the scope of the invention correspond exactly to the length of the wire mesh mats M, M', so that the cutting device 7 in a so-called Gassel cut must cut a corresponding piece out of the web of insulating material B. However, it proved advantageous to let the insulating body K protrude slightly beyond the wire mesh mats M, M', with the result that, on using the structural members P, almost continuous insulation is achieved in the walls formed from the structural members P.

The finished structural member P is fed to a transverse conveyor 42 along the production line Z-Z by a transporter 41 provided with a suitably constructed gripper 40. The transporter 41 can for example consist of a work cylinder whose piston rod is movable according to the double arrow P16. The transverse conveyor 42 pushes the finished structural members P in the arrow direction P17 off the production line Z-Z. The transverse conveyor 42 consists for example of two work cylinders whose piston rods are movable according to the double arrow P18 and each

provided with a transfer plate 43.

In Fig. 2 is shown schematically the input region of a further embodiment of an apparatus according to the invention. According to this embodiment insulating panels I2 which, compared with the insulating panels I1, I1' described in Fig. 1, have plane faces E are used. The insulating panels I1 are fed to the production line Z-Z onto the conveyor belt 12 via the insertion device 9. To produce an endless web of insulating material B, the insulating panel I2' is joined to the web of insulating material B by hot welding by means of a heating device 44. The heating device 44 essentially consists of a heating plate 45 and a heating transformer 46 which serves to heat up the heating plate 45.

The endless web of insulating material B is produced in the following manner: the insulating panel I2' located on the conveyor belt 12 is advanced according to the arrow P1 by means of the advance mechanism 16 until the insulating panel I2' impinges on the heating plate 45 abutting against the end face of the web of insulating material B. The heating plate 45 is then heated up by means of the heating transformer 46 until the abutting faces of the web of insulating material B and of the insulating panel I2' are softened. The heating plate 45 is then quickly pulled out of the gap between the insulating panel I2' and the web of insulating material B in the corresponding arrow direction of the double arrow P19 and the insulating panel I2' is advanced slightly in the direction of production P1 by means of the advance mechanism 16 in order to press the heated faces against each other and so weld the insulating panel I2' to the web of insulating material B and so join them in form-locking and force-locking relationship. As the web of insulating material B during the joining operation is advanced by the conveyor belt 12 stepwise, in time with the whole production apparatus in the direction of production P1, the heating device 44 during heating is also simultaneously moved stepwise in the corresponding arrow direction of the

double arrow P20 and, after the heating plate 45 is pulled out, moved back to the starting position in the corresponding opposite direction of the double arrow P20.

Within the scope of the invention it is possible, as shown in Fig. 2, to arrange the cutting device 7 for cutting through the web of insulating material B directly behind the heating device 44 and ahead of feeding of the wire mesh mats M, M' onto the production line Z-Z. As the cutting device 7 is also, when the web of insulating material B is cut through, advanced by the conveying chain 18 stepwise in time with the whole production apparatus in the direction of production P1, the cutting device 7 is also moved stepwise during cutting in the corresponding arrow direction of the double arrow P14 and, after cutting is over, moved back to the starting position in the corresponding opposite direction of the double arrow P14. The conveying chain 18 conveys the insulating bodies K cut off the web of insulating material B in the direction of production P1 into the subsequent processing devices of the apparatus.

As the conveying chain 18 must not extend into the paths of movement of the heating device 44 and cutting device 7, the web of insulating material B is supported in this region by at least two support elements 47 which can be moved by means of a work cylinder 48 according to the double arrow P21 out of the path of movement of the heating device 44 and cutting device 7.

Within the scope of the invention it is possible, as shown in Fig. 2, to provide two storage reels 20, 20' with wire mesh webs G, G' in order to produce the wire mesh mats M, M'. The corresponding elements in this case have the same reference numbers, which are in each case provided with or without apostrophe.

In Fig. 3 is shown schematically the input region of a further embodiment of an apparatus according to the invention. According to this embodiment, the insulating panels I2 already described in Fig. 2 are used likewise. The insulating panels I2 are fed to the production line Z-Z

onto the conveyor belt 12 via the insertion device 9. To produce an endless web of insulating material B, the insulating panel I2' is joined to the web of insulating material B by adhesion by means of an adhesive device 49. The adhesive device 49 comprises an injection nozzle 50 together with storage receptacle which is filled with a suitable adhesive. The adhesive must be suitable for adhesion of the material of the insulating panels I2 and have a drying time tailored to the production speed in order to ensure reliable joining of the insulating panel I2' to the web of insulating material B. The adhesive device 49 is movable according to the double arrow P22 in the horizontal direction and in the vertical direction. To spray the adhesive onto the face E of the insulating panel I2, the adhesive device 49 is moved in these directions of movement. In order to accelerate application of the adhesive, several adhesive devices 49 can be used simultaneously within the scope of the invention. Within the scope of the invention it is also possible to spray several insulating panels I2 simultaneously with adhesive.

The endless web of insulating material B is produced in the following manner: immediately before feeding the insulating panel I2 onto the production line Z-Z, one face E of the insulating panel I2 is provided with adhesive. The insulating panel I2 is advanced by means of the feeder 1 first in the arrow direction P2 onto the production line Z-Z and deposited on the conveyor belt 12. Then the insulating panel I2' is advanced slightly by means of the advance mechanism 16 in the direction of production P1 in order to press the adhesive-coated face of the insulating panel I2' against the end face of the insulating material B and so join the insulating panel I2' to the web of insulating material B.

In Fig. 3 is shown a further embodiment of a cutting device 7 for separating the insulating body K from the web of insulating material B. The cutting device 7 comprises a straight carriage 51 which is slidable according to the double arrow P14 along a rail 52, the movement in the

direction of production P1 taking place synchronously with advance of the web of insulating material B. Attached to the straight carriage 51 is a cutting wire 53 which is movable transversely to the web of insulating material B according to the double arrow P23 and heatable by means of a heating transformer 54. To separate the insulating body K from the web of insulating material B, the heated cutting wire 53 is moved correspondingly by the web of insulating material B and passes into the position shown in broken lines in Fig. 3. After cutting, the straight carriage 51 together with cutting wire 53 is moved back into its starting position.

Within the scope of the invention it is possible to replace the cutting device 7 shown in Fig. 1 with the cutting device described above, i.e. to arrange the cutting device described above after the trimming devices 6, 6'.

Within the scope of the invention it is possible, as shown in Fig. 3, to provide two stacks 28, 28' of wire mesh mats M, M'. The corresponding elements in this case have the same reference numbers, which are in each case provided with or without apostrophe.

It goes without saying that the embodiments shown within the scope of the general concept of the invention can be modified variously, particularly with respect to the design and construction of the devices for joining the insulating panels to form an endless web of insulating material. When using suitable adhesives, both the face of the insulating panel and the end face of the web of insulating material can be provided with adhesive.

Furthermore within the scope of the invention it is possible to provide one or both of the plane faces of the insulating panels to be joined, with a self-adhesive film. The film can be mounted already during manufacture of the insulating panels and is appropriately protected by a removable film.

Furthermore within the scope of the invention it is possible to provide the grooved and tongued faces of the insulating panels with an adhesive in addition, in order to

ensure reliable joining of the insulating panels.

The faces of the insulating panels which are adjacent for forming the web of insulating material can within the scope of the invention also be provided with other clamp joining elements which cooperate in form-locking and force-locking relationship, which are for example dovetailed.

Furthermore within the scope of the invention it is possible to use other cutting methods and devices to separate the insulating body from the web of insulating material. These methods and devices must be adapted to the material properties of the insulating materials and ensure that cutting yields edges as smooth as possible, and the material of the insulating body is not impaired in its properties, for example melted.

Claims

1. Method for the continuous manufacture of structural members, in which two parallel, flat wire mesh mats comprising longitudinal and transverse wires intersecting with each other and welded together at the points of intersection are advanced on a production line and between the wire mesh mats is introduced an insulating body, whereupon the straight link wires are passed through the insulating body and with their ends welded to the wire mesh mats, so that the latter are held a predetermined distance apart, characterised in that first an endless, coherent web of insulating material (B) is produced from individual insulating panels (I1, I1'; I2, I2') and advanced and then the insulating body (K) is cut off this web of insulating material (B) in a selectable length.

2. Method according to claim 1, characterised in that the insulating panels (I1, I1'; I2, I2') are conveyed singly and successively onto the production line (Z-Z) and displaced relative to each other in their longitudinal direction (P1) to produce the web of insulating material (B), with the result that the faces (N, F; E) of the adjacent insulating panels (I1, I1') are joined together in form-locking and force-locking relationship to form the web of insulating material (B).

3. Method according to either of claims 1 or 2, characterised in that, to produce the endless, coherent web of insulating material (B), the insulating panels (I1, I1') are joined together with their faces (N, F) in form-locking and force-locking relationship by clamping.

4. Method according to claim 3, characterised in that the faces (N, F) are joined together in form-locking and force-locking relationship by a tongue and groove clamping joint.

5. Method according to either of claims 3 or 4,

characterised in that the faces (N, F) are provided with an adhesive.

6. Method according to either of claims 1 or 2, characterised in that insulating panels (I2, I2') with plane faces (E) are used and, to produce the endless, coherent web of insulating material (B), an adhesive is applied to at least one face (E) of adjacent insulating panels (I2, I2') or the face is provided with a self-adhesive film.

7. Method according to either of claims 1 or 2, characterised in that insulating panels (I2, I2') with plane faces (E) are used and, to produce the endless, coherent web of insulating material (B), the face (E) of one insulating panel (I2') and the end face of the web of insulating material (B) are heated together and joined by welding.

8. Apparatus for carrying out the method according to any of claims 1 to 7, with two storage magazines for wire mesh webs, with straightening and cutting devices for each wire mesh web, with a feeder for insulating panels, with at least one assembly of link wire storage reels together with associated link wire feeders and cutting devices, with link wire welding devices, with link wire trimming devices, and with several conveying devices coupled together for the insulating body, for the wire mesh webs or for wire mesh mats, for the mesh body and for the structural member, characterised in that an advance mechanism (16) for the displacement of insulating panels (I1, I1'; I2, I2') relative to a web of insulating material (B) for the purpose of forming a form-locking and force-locking joint between the insulating panels (I1, I1'; I2, I2') and the web of insulating material (B), and a cutting device (7) displaceable parallel to the production line (Z-Z) for cutting an insulating body (K) off the web of insulating material (B), are provided.

9. Apparatus according to claim 8, characterised in that the cutting device (7) comprises at least one drivable separating disc (39) movable in horizontal and vertical directions.
10. Apparatus according to claim 8, characterised in that the cutting device (7) comprises a cutting wire (53) which is displaceable transversely to the web of insulating material (B) and heatable by means of a heating transformer (54).
11. Apparatus according to any of claims 8 to 10, characterised in that, to produce the web of insulating material (B), there is provided a heating plate (45) with which the face (E) of one insulating panel (I2') and the end face of the web of insulating material (B) can be heated together.
12. Apparatus according to any of claims 8 to 10, characterised in that, to produce the web of insulating material (B), there is provided at least one adhesive device (49) which is movable in horizontal and vertical directions and with which at least one face (E) of adjacent insulating panels (I2') can be provided with an adhesive coat.
13. Apparatus according to any of claims 8 to 12, characterised in that the cutting device (7) is arranged behind the trimming devices (6, 6') in the direction of production.
14. Apparatus according to any of claims 8 to 12, characterised in that the cutting device (7) is arranged in front of the conveying device (18) for the insulating body (K) and in that in the region between the feeder (12) for the insulating panels (I1', I2') and the conveying device (18) for the insulating body (K) are provided support elements (47) movable into the path of advance of the web

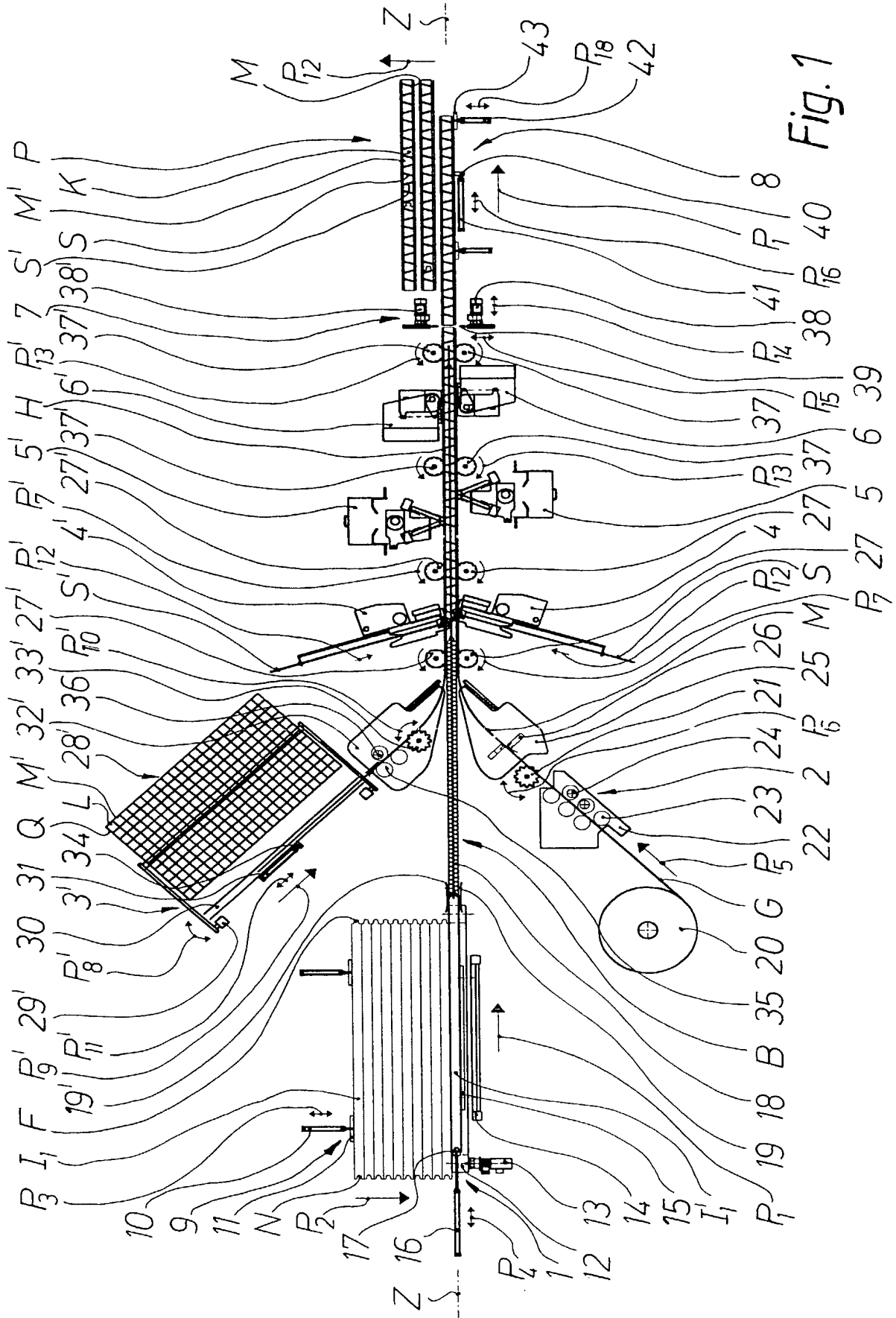
of insulating material (B).

15. Apparatus according to any of claims 8 to 14, characterised in that a transporter (29, 29') is provided for taking wire mesh mats (M, M') already cut to length from at least one stack of mats (28, 28'), and an insertion device (31, 31') is provided for insertion of the wire mesh mats (M, M') in a shaping device (32, 32'), and a drivable advance roller (33, 33') is provided for insertion of the straightened wire mesh mats (M, M') in the production line (Z-Z), wherein the advance roller (33, 33') is coupled to the conveying device (12) for the web of insulating material (B) and insulating body (K), the conveying devices (27, 27') for the wire mesh mats (M, M'), the conveying devices (37, 37') for the mesh body (H) and, if occasion arises, to the advance roller (21, 21') for a wire mesh web (G, G').

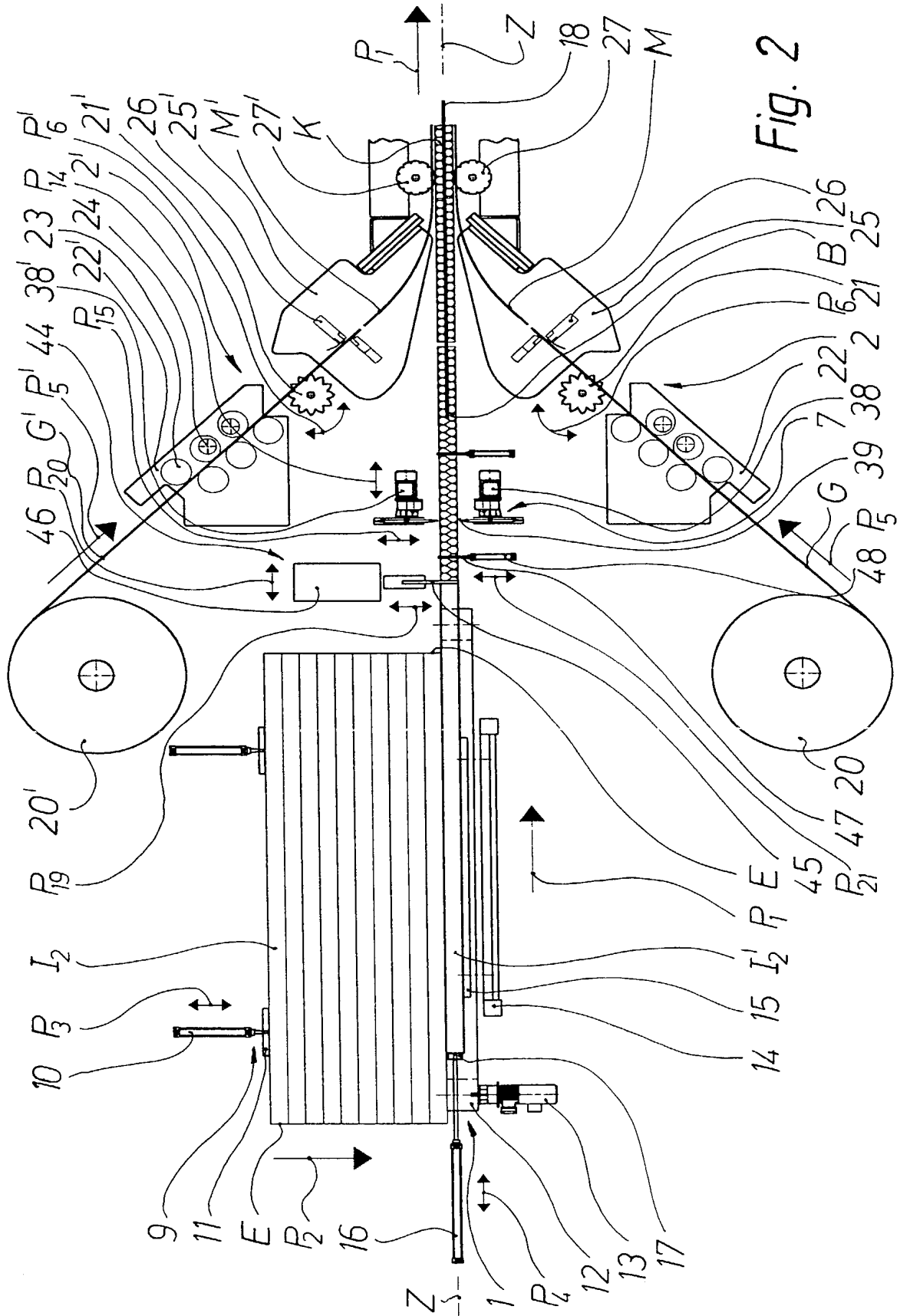
Abstract

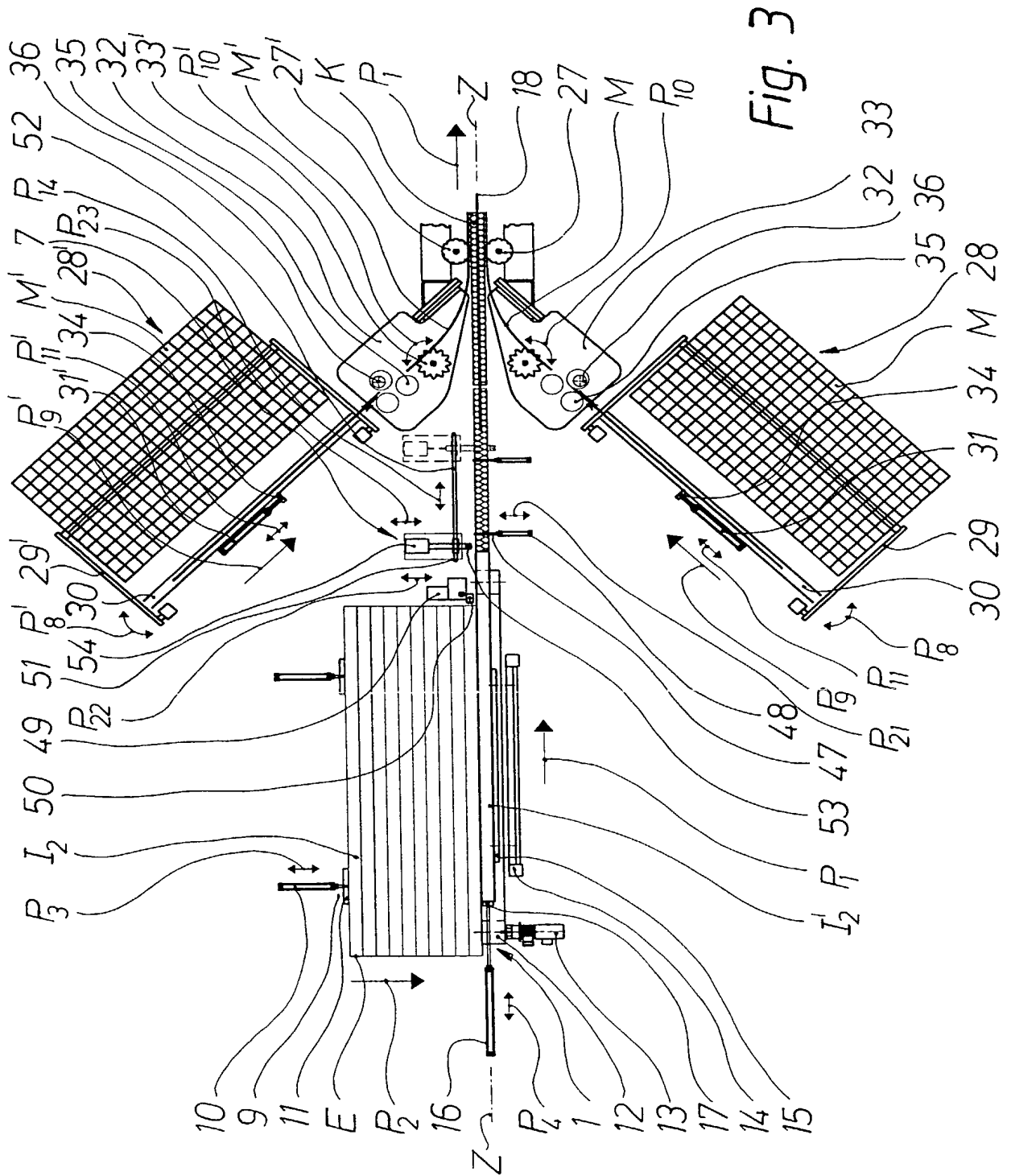
Method and apparatus for the continuous manufacture of structural members, in which two parallel, flat wire mesh mats comprising longitudinal and transverse wires intersecting with each other and welded together at the points of intersection are advanced on a production line and between the wire mesh mats is introduced an insulating body, whereupon the straight link wires are passed through the insulating body and with their ends welded to the wire mesh mats, so that the latter are held a predetermined distance apart, wherein first an endless, coherent web of insulating material is produced from individual insulating panels and advanced and then the insulating body is cut off this web of insulating material in a selectable length.

(Fig. 1)



2/3







APPLICATION FOR UNITED STATES LETTERS PATENT

PCT Declaration and Power of Attorney (35 U.S.C. 371(c)(4))

PCT Application - United States Designated Office

As a below named inventor, I declare that:

My residence, post office address and citizenship are as stated below next to my name; I believe that I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

METHOD AND PLANT FOR CONTINUOUSLY PRODUCING CONSTRUCTION ELEMENTS

the specification of which was deposited in the U.S. Patent and Trademark Office on April 9, 2001 under Serial No. 09/807,106.

I have reviewed and understand the contents of said specification, including claims.

I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR §1.56.

I claim priority benefits under 35 USC §119 of: (i) any foreign application(s) for patent or inventor's certificate listed below; or (ii) any United States provisional application(s) listed below; and have also identified below any foreign application(s) for patent or inventor's certificate, or PCT international application having a filing date before that of the application(s) on which priority is claimed.

COUNTRY	APPLICATION NUMBER	DATE (day, month, year)	PRIORITY CLAIMED
AUSTRIA	1692/98	09 10 98	yes <u>X</u> no <u> </u>
			yes <u> </u> no <u> </u>

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

⑦ I appoint the following attorneys to prosecute this application and to transact all business in the U.S. Patent & Trademark Office connected therewith: Leonard Holtz, Reg. No. 22,974; Herbert Goodman, Reg. No. 17,081; Thomas Langer, Reg. No. 27,264; Marshall J. Chick, Reg. No. 26,853; Richard S. Barth, Reg. No. 28,180; Douglas Holtz, Reg. No. 33,902; and Robert P. Michal, Reg. No. 35,614.

CORRESPONDENCE AND CALLS TO:

FRISHAUF, HOLTZ, GOODMAN, LANGER & CHICK, P.C.
767 Third Avenue - 25th Floor Tel.: (212) 319-4900
New York, New York 10017-2023 Fax.: (212) 319-5101

INVENTOR: SIGNATURE

DATE

RESIDENCE AND POST OFFICE ADDRESS

1-00 Sign: <u>[Signature]</u> Type: <u>Klaus RITTER</u>	Date: <u>05.03.2002</u> Citizen of: AUSTRIA	Residence: (City & Country): <u>GRAZ, AUSTRIA</u> <u>ATX</u> Post Office Address: <u>Peterstalstrasse 157</u> <u>A-8042 Graz, Austria</u> <u>ATX</u>
2-01 Sign: (DECEASED) Type: Gerhard RITTER	Date: Citizen of: AUSTRIA	Residence: (City & Country): <u>GRAZ, AUSTRIA</u> <u>ATX</u> Post Office Address: <u>Unterer Plattenweg 47</u> <u>A-8043 Graz, Austria</u>
2-11 Sign: <u>[Signature]</u> Type: <u>Ingrid RITTER</u> (appointed administrator for inventor Gerhard RITTER, deceased)	Date: <u>05.03.2002</u> Citizen of: AUSTRIA	Residence: (City & Country): <u>GRAZ, AUSTRIA</u> <u>ATX</u> Post Office Address: <u>Unterer Plattenweg 47</u> <u>A-8043 Graz, Austria</u>
Sign: <u>[Signature]</u> Type: <u>Gerhard SCHMIDT</u>	Date: <u>05.03.2002</u> Citizen of: AUSTRIA	Residence: (City & Country): <u>GRAZ, AUSTRIA</u> Post Office Address: <u>Rosengasse 7</u> <u>A-8042 Graz, Austria</u>



APPLICATION FOR UNITED STATES LETTERS PATENT

PCT Declaration and Power of Attorney (35 U.S.C. 371(c)(4))

PCT Application - United States Designated Office

As a below named inventor, I declare that:

My residence, post office address and citizenship are as stated below next to my name; I believe that I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

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the specification of which was deposited in the U.S. Patent and Trademark Office on April 9, 2001 under Serial No. 09/807,106.

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COUNTRY	APPLICATION NUMBER	DATE (day, month, year)	PRIORITY CLAIMED
AUSTRIA	1692/98	09.10.98	yes <u>X</u> no _____
			yes _____ no _____

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

I appoint the following attorneys to prosecute this application and to transact all business in the U.S. Patent & Trademark Office connected therewith: Leonard Holtz, Reg. No. 22,974; Herbert Goodman, Reg. No. 17,081; Thomas Langer, Reg. No. 27,264; Marshall J. Chick, Reg. No. 26,853; Richard S. Barth, Reg. No. 28,180; Douglas Holtz, Reg. No. 33,902; and Robert P. Michal, Reg. No. 35,614.

CORRESPONDENCE AND CALLS TO:

FRISHAUF, HOLTZ, GOODMAN, LANGER & CHICK, P.C.
767 Third Avenue - 25th Floor Tel.: (212) 319-4900
New York, New York 10017-2023 Fax.: (212) 319-5101

INVENTOR: SIGNATURE	DATE	RESIDENCE AND POST OFFICE ADDRESS
Sign: <u>Klaus Ritter</u>	Date: <u>09.07.01</u>	Residence: (City & Country): GRAZ, AUSTRIA
Type: <u>Klaus RITTER</u>	Citizen of: AUSTRIA	Post Office Address: Peterstalstrasse 157 A-8042 Graz, Austria
Sign: <u>Ingrid Ritter</u>	Date: <u>09.07.01</u>	Residence: (City & Country): GRAZ, AUSTRIA
Type: <u>Ingrid RITTER</u> (appointed administrator for inventor Gerhard RITTER, deceased)	Citizen of: AUSTRIA	Post Office Address: Unterer Plattenweg 47 A-8043 Graz, Austria
Sign: <u>Gerhard Schmidt</u>	Date: <u>09.07.01</u>	Residence: (City & Country): GRAZ, AUSTRIA
Type: <u>Gerhard SCHMIDT</u>	Citizen of: AUSTRIA	Post Office Address: Rosengasse 7 A-8042 Graz, Austria